

Work Order ID 133153

133153

Page 1

Tuesday, May 26, 2015 12:48:43 PM

Item ID: D3847-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 5/23/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/26/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ Date: MAY 27 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	C								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3847

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

12 Ø Jm15-5-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 Ø Jm15-5-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 5/23/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/26/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Large Fab

Large Fab

Memo

Weld hardcoat as per dwg

A/R 2059B Batch: 130145

0.00

0.00

12

15-07-10

JBL

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

(12)

DAS
38
9-89

JUL 10 2015

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

(12)

DAS
38
9-89
JUL 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : _____																					

Work Order ID 133153

133153

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Tuesday, May 26, 2015 12:48:44 PM

Item ID: D3847-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 5/23/15 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 5/26/15 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>m 130746.</i> Memo START TIME: <i>1:15</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>1:45</i>	0.00 0.00				<i>12</i>	<i>15-7-13</i>		<i>DAS 34 9-89</i>
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>12</i>	<i>15-07-15</i>		<i>DAS 9 9-89</i>
193 *193* HandFinish Hand Finishing	Memo APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG TEXTURE COATING BATCH: <i>M132390</i>	0.00 0.00							<i>DAS 02 9-89 15-07-20</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Work Order ID 133153

133153

Page 5

Tuesday, May 26, 2015 12:48:44 PM

Item ID: D3847-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 5/23/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/26/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

196

QC3- Inspect Part Finish

0.00

106

QC

Memo

0.00

Quality Control

DAS
38
9-89

JUL 20 2015

200

Identify as per dwg & Stock Location: FP-001 0.00

200

Packaging

Memo

0.00

Packaging

LOCATION : FP001

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLJ JUL 20 2015

May 7/20/15

AS-7-20

112 of all 13/07/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

Tuesday, May 26, 2015 12:48:43 PM

Page 1

Work Order ID: 133153

133153

Parent Item: D3847-1

D3847-1

Parent Item Name: Wearpad

Start Date: 5/23/15

Required Date: 5/26/15

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV:B

14.11.25 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	252.4076	0.1236	1301053			

M304S16GA

304/316 Sheet .063

(2)

Jm15-5-29

Location

Loc Qty

Loc Code

MAT019

252.4076

m131384

99.1176

m131503

153.29

131503

DQA: _____ Date: _____

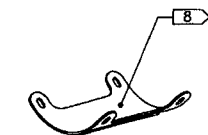


WORK ORDER NON-CONFORMANCE / UPDATE

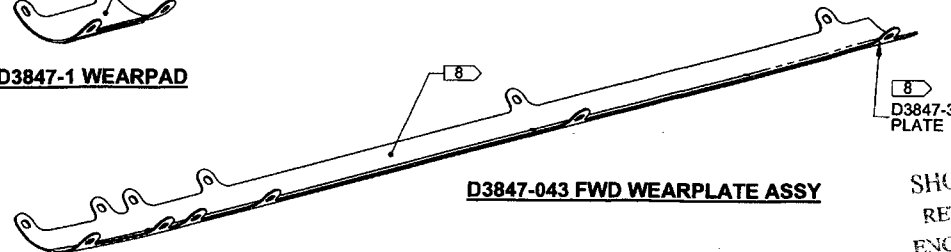
QA Closed: _____ Date: _____

Work Order update only ☐

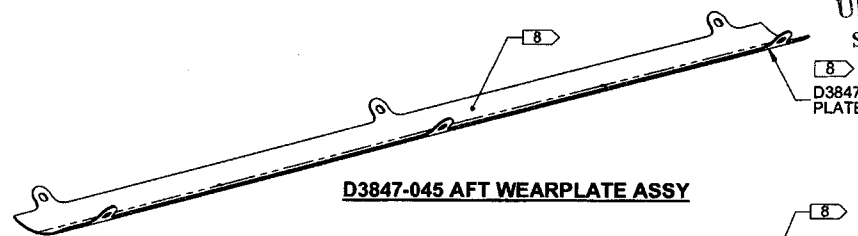
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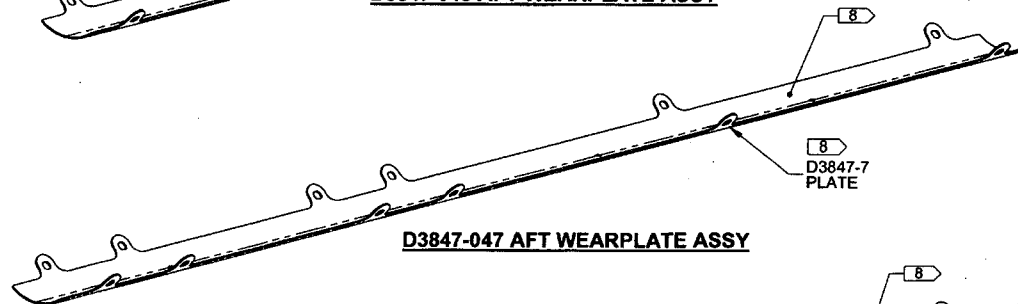
D3847-1 WEARPAD



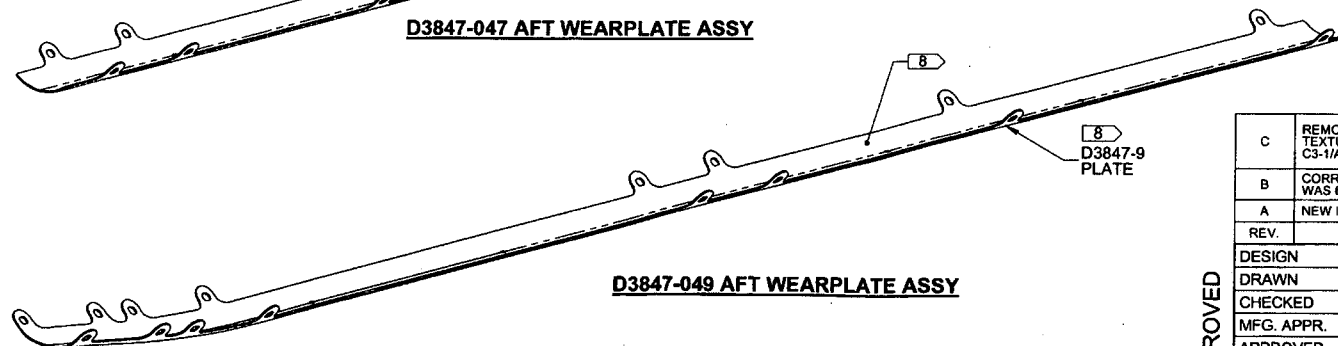
D3847-043 FWD WEARPLATE ASSY



D3847-045 AFT WEARPLATE ASSY



D3847-047 AFT WEARPLATE ASSY



D3847-049 AFT WEARPLATE ASSY

ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
31	A/R	A/R	A/R	A/R	TEXTURED COATING	SEALANT

SHOW
RET
ENGINE

UNCONTROL

SUBJECT TO

WITHOUT

WORK

NO 133153

MLJ

150527

NOTES:

1) MATERIAL: N/A

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX"

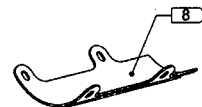
7) WEIGHT: D3847-043 = 1.48 lbs

D3847-045 = 1.29 lbs

D3847-047 = 1.70 lbs

D3847-049 = 4.88 lbs

8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9



D3847-11 WEARPAD

RELEASED

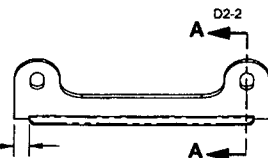
2014 NOV 24

ECN 14-628

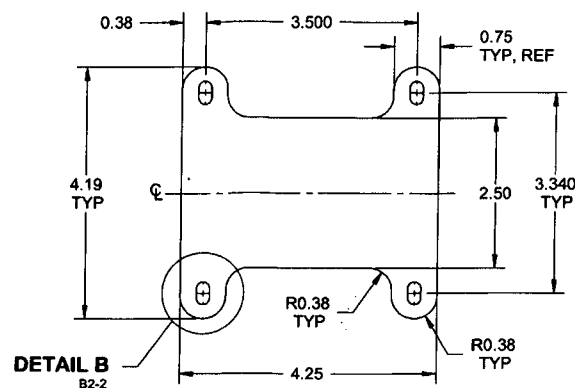
C	REMOVED D3846-31-51-71-9 GASKETS, ZN D2-1. ADDED TEXTURED COATING, ZN B3-1. UPDATED WEIGHTS, ZN C3-1/A8-2	AK	14.08.06
B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AK	KENT, WA	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3847	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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APPROVED

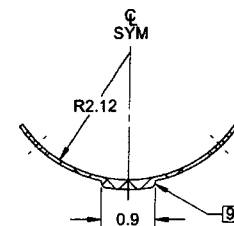
0.25
TYP, REF



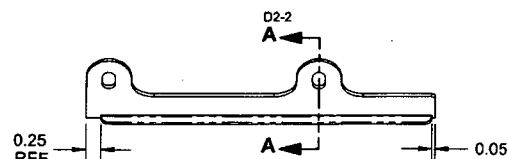
D3847-1 WEARPAD
MADE FROM D3847-1F FLAT PATTERN



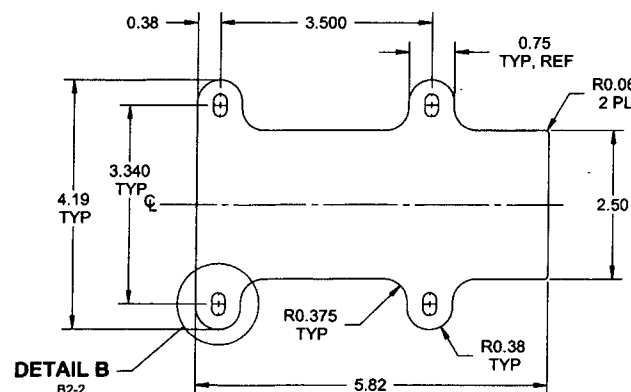
D3847-1F FLAT PATTERN



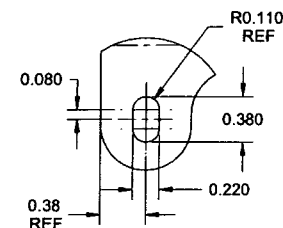
SECTION A-A
D7-2
B7-2



D3847-11 WEARPAD
MADE FROM D3847-11F FLAT PATTERN



D3847-11F FLAT PATTERN



DETAIL B
TYP, SCALE 2X
C5-2
B5-2

RELEASED

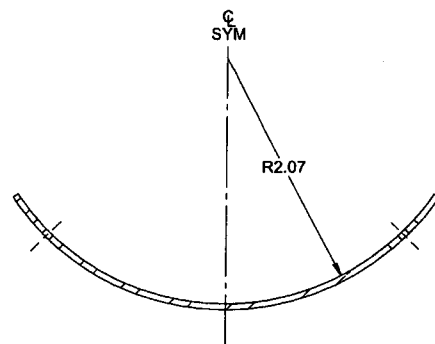
2014 NOV 24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3847-1 = 0.32 lbs
D3847-11 = 0.47 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED

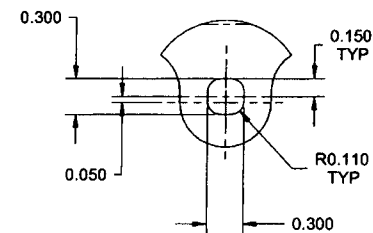
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MFG. APPR.	JLM	D3847	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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SECTION C-C
SCALE 4X

D4-3
D4-4
D3-5
D3-6



DETAIL D
TYP. SCALE 4X

B5-3
B6-4
B3-5
B5-6

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2014 NOV 24 *q*

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MFG. APPR.	JLM	D3847	SHEET 7 OF 7
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